

Date: Thursday, 22/03/2007 3:19:57 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)		
Job Number	: 31333		Part Number	: D26022		
Estimate Number	: 11001		Drawing Number	: D2602 REV A1		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 22/03/2007 S.O. No. : N/A		Drawing Revision	: A1		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 10/04/2007 Qty: 10 Um: Each		
Previous Run	: 31333					
Written By	: <u>L</u>					
Checked & Approved By	: <u>L</u>					
Comment	: Est. E 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-1 Est Rev:E Now On Waterjet 07-03-22 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet 
<b>Comment:</b> Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <u>M104025</u> <u>ml 07 04 19</u>		
2.0	WATER JET	FLOW WATER JET 
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D2602 *****Same Cutting File for -1 & -2 ***** Dwg Rev: <u>A1</u> <u>ml 07 04 20</u>		
2-Deburr if necessary <u>SAY 07/04/24</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 07 04 20</u>		
4.0	QC8	SECOND CHECK <u>J 07 04 21</u>
<b>Comment:</b> SECOND CHECK		

Date: Thursday, 22/03/2007 3:19:57 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 31333

Part Number: D26022

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

*SAW 07/04/24 no*

Form as per Dwg D2602

*SB 07/05/03*

10

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*107/05/04 10*

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*FF 07-05-04*

10

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*SB 07/05/04*

10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*FF 07-05-04*

10

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*10.07/05/04*

10

Job Completion



*10.07/05/04*



Date: Tuesday, 3/20/2007 12:03:24 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)		
Job Number	: 31332		Part Number	: D26021		
Estimate Number	: 11000		Drawing Number	: D2602 REV A1		
P.O. Number	:		Project Number	: N/A		
This Issue	: 3/20/2007	S.O. No. :	Drawing Revision	: A1		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type :	Due Date	Qty:	10	Um: Each
Previous Run	: 25471					
Written By	:					
Checked & Approved By	: <u>Kim Johnston</u>					
Comment	: Est. D 04.02.25 Reformat KJ/RF					
Note: Issue with part number D2602-2						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
Comment: Qty.: 1.4146 sf(s)/Unit Total : 14.1456 sf(s) 2024-T3 .040 sheet Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch <i>W. Johnston</i>		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut Blank per template DT8243		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA145 and Dwg D2602 Stack of 10 Identify as D2602-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 31332

Part Number: D26021

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31332
Description: Console Side LH/RH	Part Number:	D2602-1/-2
Inspection Dwg: D2602 Rev: A1		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	100-221
Date:	07 04 20

**Audited by:** ✓

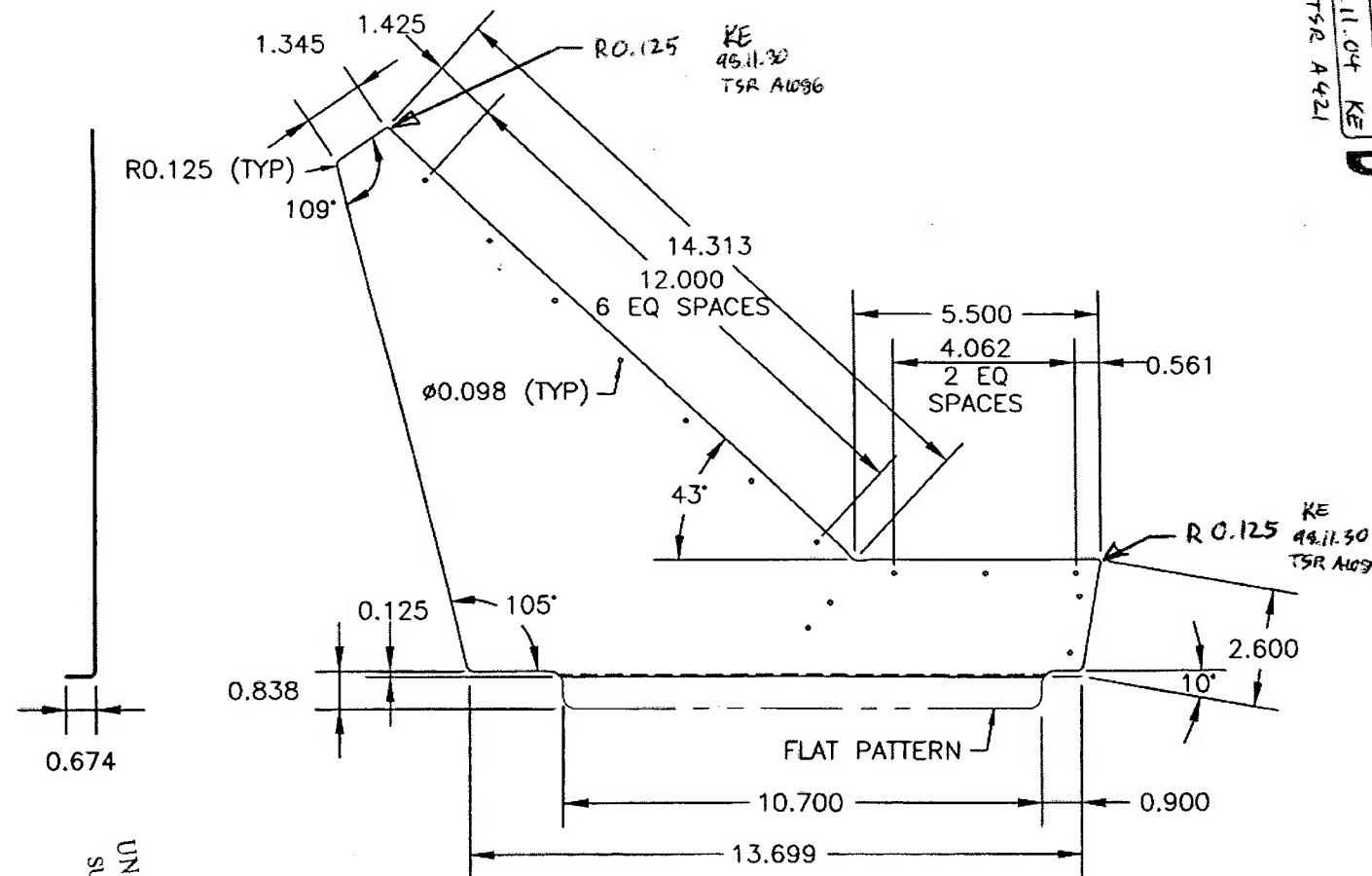
<b>Prototype Approval:</b>	N/A
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	TT

RELEASED  
17.11.04 KE  
TSP 4421

TSR A 421

DESIGN <i>CL</i>		DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>		APPROVED <i>SJ</i>	DRAWING NO. D2602	SHEET 1 OF 1 REV. A
DATE 97.10.22		TITLE CONSOLE SIDE		SCALE 1:4
A	97.10.22	D2602	WAS D206-547-21 / -22	
AI	<del>GR2</del> 02.06.04	ADJ	FINISH	



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK  
PROFILE CONTROLLED BY FOLIO H2602  
BFND RADIUS 0.093

BEND RADIUS 0.093  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 **AI**  
D2602-1 SHOWN  
D2602-2 OPPOSITE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31332